

Work Order ID 142437 - 1

142437

Page 1

Wednesday, March 09, 2016 12:33:53 PM

Item ID: D5235-041

Revision ID:

Item Name: LH Step Assembly

Start Date: 3/28/2016 Start Qty: 4.00

Required Date: 4/1/2016 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: MAR 09 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D5235	A
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110

0.05

110

Small Fab

Small Fab

Memo

0.00

1- ASSEMBLE FIXTURE DT10150 WITH BLOC "A","B" AND "C" TO MANUFACTURE D5235-041.

2- ASSEMBLE D5273-041 FITTINGS TO D5274-1 STEP WITH PROSEAL AS PER DWG
A/R PROSEAL: 136953

3- INSERT ALL PARTS TOGETHER IN FIXTURE DT10150 AND TRANSFER DRILL HOLES USING DT10186 FOR D5271-3/-4 AND DT 10185 FOR D5271-1 AS PER DWG AND NOTES 9,10.

4- DISASSEMBLE AND DEBURR.

5- a) USE DT10170 DRILL JIG TO DRILL NUT PLATE HOLES IN D5272-1/-3 TUBE AS PER DWG.
b) DEBURR
c) TOUCH UP HOLES WITH ALODINE ONLY
d) INSTALL NUTPLATES IN TUBES

6- TOUCH UP HOLES WITH ALODINE ONLY ON D5271-1/-3 AND D5273-041 FITTINGS.

7- USE DT10150 TO RE-ASSEMBLE REST OF THE PARTS TOGETHER USING PROSEAL AS PER DWG
A/R PROSEAL: 136953

2X

DAS
36
9-89
17/06/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 142437

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Page 2

Item ID: D5235-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: LH Step Assembly
 Start Date: 3/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/1/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	CURE TIME 24h: _____								
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 JUN 14 2017
130 *130* Spray Paint Spray Painting	Memo PRIME AS PER DWG AND QSI005 4.2.1.3.3 (LET CURE BEFORE PAINTING AS PER QSI005) PRC DESOTO PRIMER: <u>136772</u> PAINT AS PER DWG AND QSI005 4.2.2.3 WHITE IMIRON PAINT: <u>137327</u>	0.07 0.00				1			DAS 41 9-89 JUN 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Work Order ID 142437

Wednesday, March 09, 2016 12:33:53 PM

142437

Page 3

Item ID: D5235-041 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 4/1/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC14- Inspect Spray Paint	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Wing Walk as per dwg QSI005 4.4 Batch M137942	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS 15 9-89
DAS 38 9-89
JUL 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 142437

Wednesday, March 09, 2016 12:33:53 PM

142437

Page 4

Item ID: D5235-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: LH Step Assembly
Start Date: 3/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/1/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							SMB 17/7/17
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									17/7/18
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

JUL 18 2017

~~JUL 17 2017~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Wednesday, March 09, 2016 12:33:57 PM

Page 1

Work Order ID: 142437

142437

Parent Item: D5235-041

D5235-041

Parent Item Name: LH Step Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 15.07.28 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5271-1		Manufactured	No				Each	0.0000		42		DAS 8 9-89	
D5271-1									**	140320			
Forward Fitting													
D5271-3		Manufactured	No				Each	0.0000		42	DAS 30 9-89		
D5271-3									**	3140323			APR 11 - 2016
LH Aft Fitting													
D5272-3		Manufactured	No				Each	19.0000		42		DAS 36 9-89	
D5272-3									**			17/03/30	
Aft Tube													

Location Loc Qty Loc Code

GA 18

140815 18

prelim 1

134702 1

D5272-1 Manufactured No

D5272-1

Fwd Tube

Each 19.0000

**

Location Loc Qty Loc Code

GA 18

140318 18

prelim 1

134701 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

Wednesday, March 09, 2016 12:33:57 PM

Page 2

Work Order ID: 142437

Parent Item: D5235-041

Parent Item Name: LH Step Assembly

142437

D5235-041

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

D5273-041

Manufactured No

Each 1.0000

D5273-041

End Fitting Assembly

**

84
140324

DAS
6
9-89

Location

Loc Qty

Loc Code

prelim

135150

1

Each 0.0000

D5274-1

Manufactured No

D5274-1

Step Extrusion

D5291-041

Manufactured No

D5291-041

Radius Block Assembly

Each 179.0000

**

5628

APR 07 2016
17/03/30
DAS
36
9-89

Location

Loc Qty

Loc Code

prelim

4

135144

4

ST162

175

140319

175

Each 1,022.000

**

28
TT2 56

DAS
6
9-89

APR 07 2016

MS20426AD4-6

Purchased

No

MS20426AD4-6

Rivet

Location

Loc Qty

Loc Code

GA

1014

M128812

16

M133234

998

ST311

8

M132536

8

DAS
6
9-89

APR 07 2016

DA
36
9-89

CR3212-4-5

134574

56x

DA
36
9-89

17/06/13

Wednesday, March 09, 2016 12:33:57 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
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Page 3

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Parent Item: D5235-041

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Parent Item Name: LH Step Assembly

Start Date: 3/28/2016

Required Date: 4/1/2016

Start Qty: 4.00

Required Qty: 4.00

MS24694-S50

Purchased

No

Each

724.0000

4824

DAS

6

134502

9-89

MS24694-S50

Screw

LocationLoc QtyLoc Code

over006

400

m134370

400

ST284

324

m133031

24

m133990

300

Each

274.0000

5628

DAS

6

9-89

MS24694-S98

Purchased

No

MS24694-S98

Screw

LocationLoc QtyLoc Code

over006

200

m133990

100

m134134

100

ST283

74

m133483

74

10

12

Wednesday, March 09, 2016 12:33:57 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



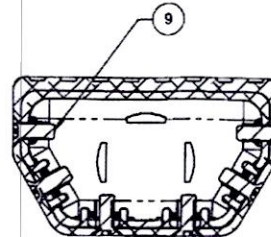
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

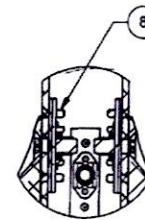
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

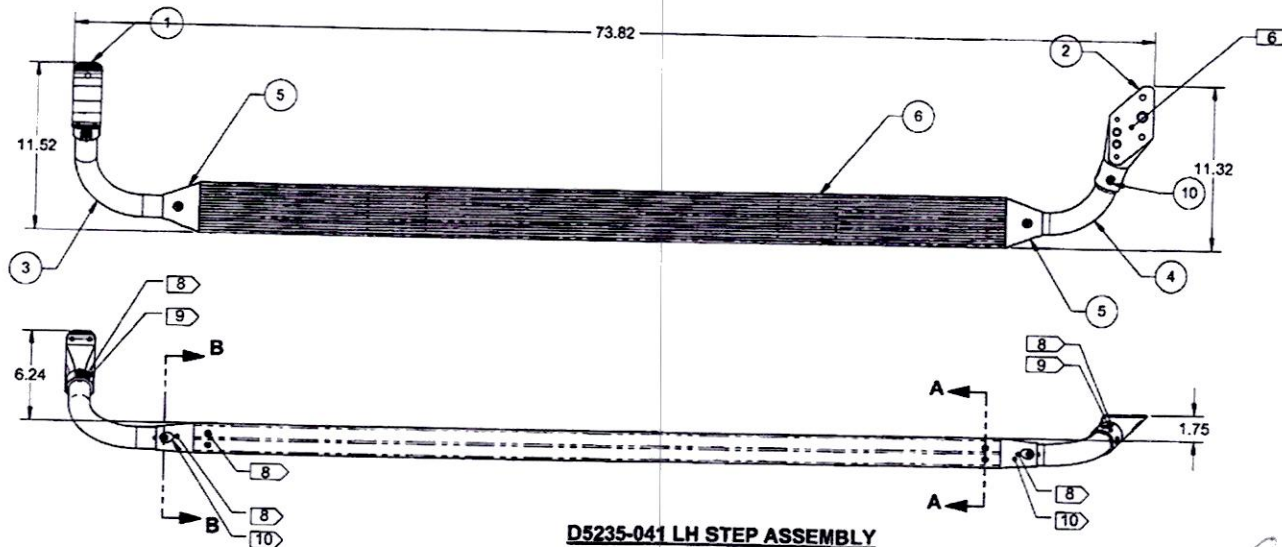
ITEM	QTY. -041	P/N	DESCRIPTION
	X	D5235-041	LH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-3	LH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-041	END FITTING ASSEMBLY
6	1	D5274-1	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	12	MS24694-S50	SCREW
10	14	MS24694-S98	SCREW



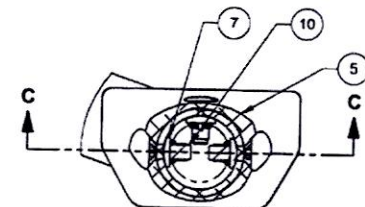
SECTION A-A



SECTION C-C



D5235-041 LH STEP ASSEMBLY



SECTION B-B

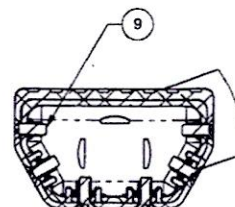
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2. PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-041" PER QSI 044 6.1
 - 7) WEIGHT: 10.49 lbs
 - 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
 - 9) TRANSFER DRILL FROM D5271-1/3 TO D5272-1/3
 - 10) TRANSFER DRILL FROM D5273-041 TO D5272-1/3

RELEASED
2015-12-07
EN 15-649 DM

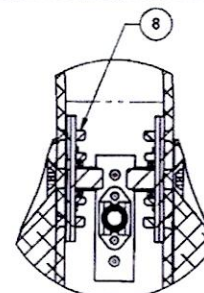
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A		ISSUE	CC	15.06.09
REV.	DESCRIPTION		BY	DATE
DESIGN	CC	DART AEROSPACE USA, INC		
DRAWN	CC	EUGENE, OREGON, USA		
CHECKED	VS	DRAWING NO.	REV. A	
MFG. APPR.	JLM	D5235	SHEET 1 OF 4	
APPROVED	HS	TITLE	SCALE	
DE APPR.	DS	AW139 CABIN STEP	NTS	
DATE	15.06.09		COPYRIGHT © 2015 BY DART AEROSPACE USA, INC	
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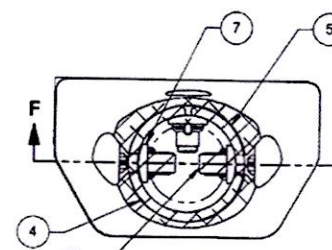
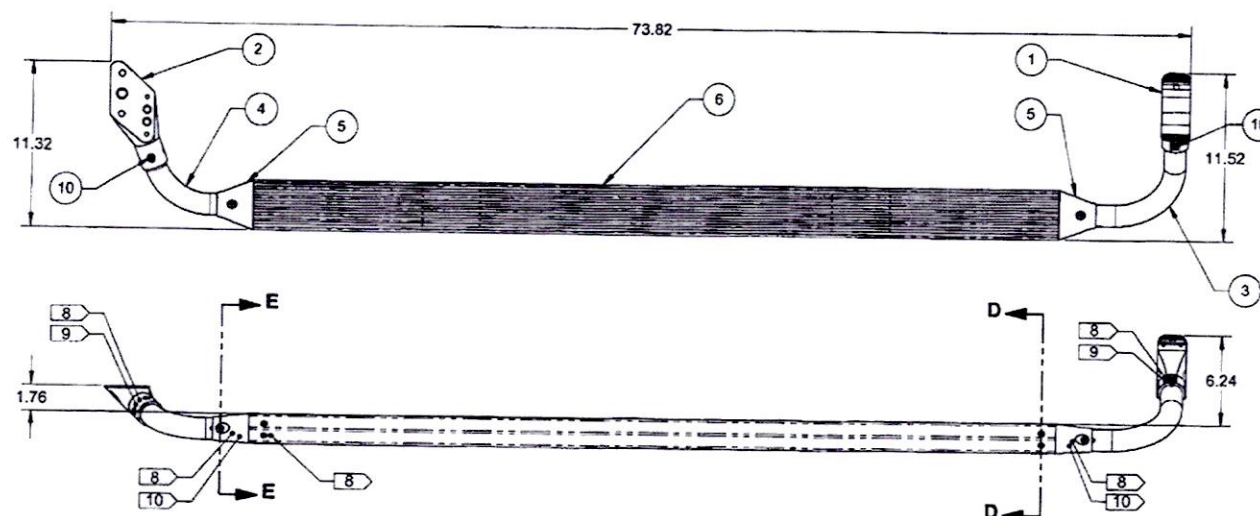
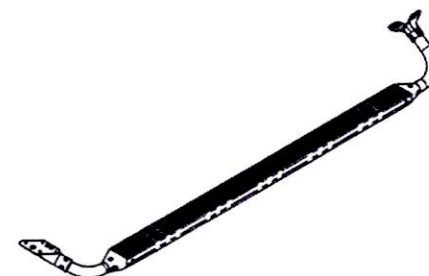
ITEM	QTY. .042	P/N	DESCRIPTION
	X	D5235-042	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-041	END FITTING ASSEMBLY
6	1	D5274-1	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	12	MS24694-S50	SCREW
10	14	MS24694-S98	SCREW



SECTION D-D



SECTION F-F



SECTION E-E

D5235-042 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-042" PER QSI 044 6.1
- 7) WEIGHT: 10.49 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/4 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-041 TO D5272-1/3

RELEASED
2015-12-07

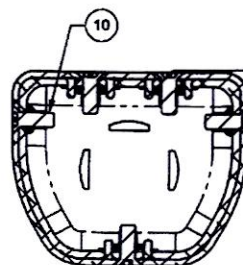
APPROVED

DESIGN	CC
DRAWN	CC
CHECKED	VS
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	15.06.09

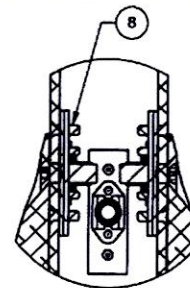
DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWING NO.	REV. A
D5235	SHEET 2 OF 4
TITLE	SCALE
AW139 CABIN STEP	NTS

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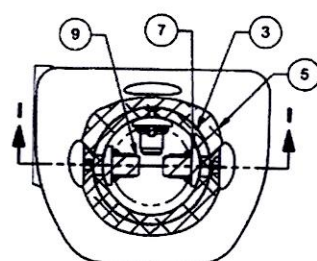
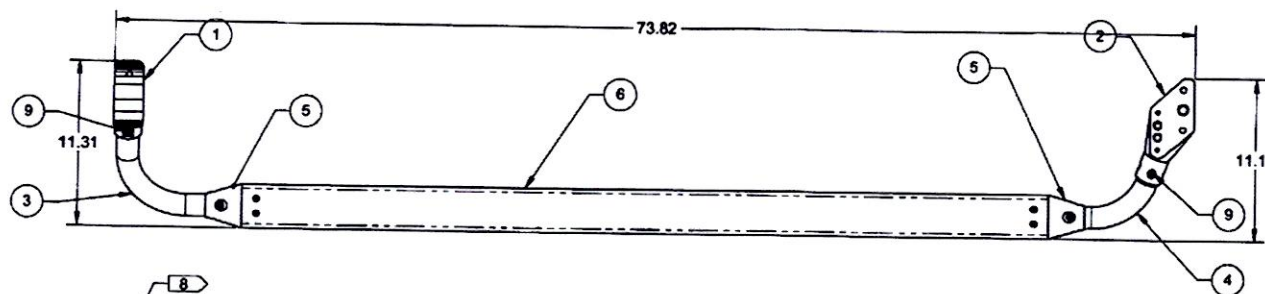
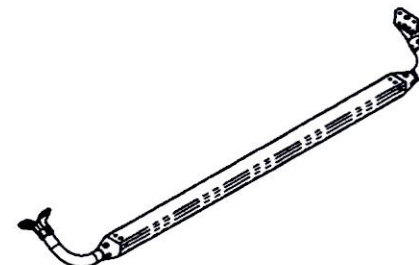
ITEM	QTY. -043	P/N	DESCRIPTION
	X	D5235-043	LH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-3	LH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-043	END FITTING
6	1	D5274-3	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



SECTION G-G



SECTION I-I



SECTION H-H



D5235-043 LH STEP ASSEMBLY

NOTES:

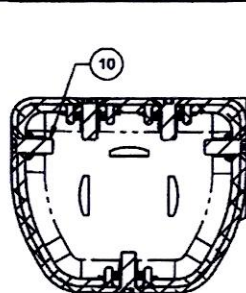
- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-043" PER QSI 044 6.1
- 7) WEIGHT: 8.66 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/3 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/3

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2015-12-07

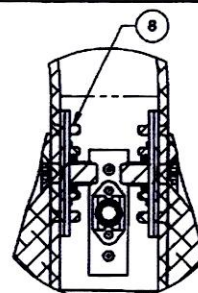
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CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5235	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AW139 CABIN STEP	NTS
DATE	15.06.09	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC	

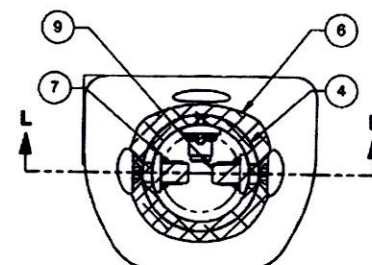
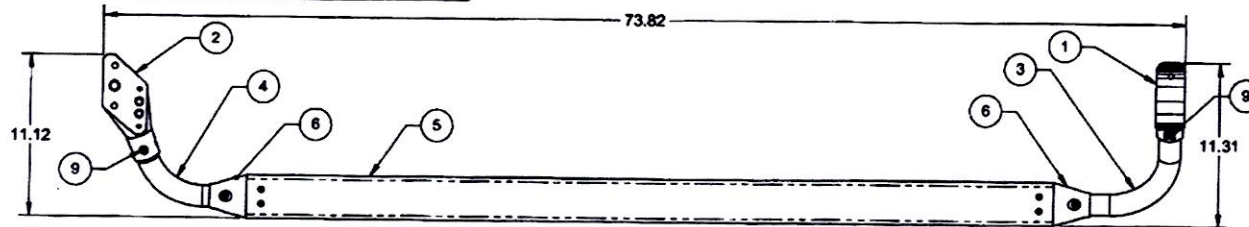
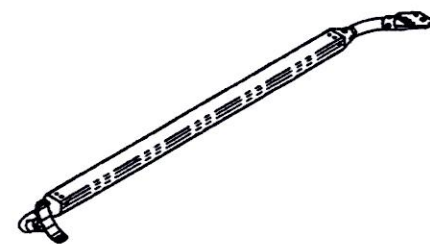
ITEM	QTY. -044	P/N	DESCRIPTION
	X	D5235-044	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	1	D5274-3	STEP EXTRUSION
6	2	D5273-043	END FITTING
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	MS20426AD4-6	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



SECTION J-J



SECTION L-L



SECTION K-K



D5235-044 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-044" PER QSI 044 6.1
- 7) WEIGHT: 8.66 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/4 TO D5272-1/3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/3

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MFG. APPR.	JLM	D5235	SHEET 4 OF 4
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DE APPR.	DS	AW139 CABIN STEP	NTS
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LOT TRACKING !!

Reason	Parent Item ID	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt	Last Cost Amt	Trans Type
142437	D5271-3	-2	140323	4/28/2017 8:54:20 AM	\$222.76	\$222.76	Issue
142437	D5272-1	-2	140318	4/28/2017 8:54:20 AM	\$74.68	\$71.17	Issue
142437	D5272-3	-2	140815	4/28/2017 8:54:20 AM	\$57.88	\$57.75	Issue
142437	D5273-041	-4	140324	4/7/2016 11:58:07 AM	\$187.65	\$179.74	Issue
142437	D5274-1	-2	140326	4/28/2017 8:56:12 AM	\$197.22	\$196.49	Issue
142437	D5291-041	-28	140319	4/7/2016 11:58:07 AM	\$15.36	\$16.84	Issue
142437	MS20426AD4-6	-56	M132536	4/7/2016 11:58:07 AM	\$.01	\$.01	Issue
142437	MS24694-S50	-24	m134502	4/7/2016 11:58:07 AM	\$.05	\$.05	Issue
142437	MS24694-S98	-18	m133483	4/7/2016 11:58:07 AM	\$.15	\$.15	Issue
142437	MS24694-S98	-10	m133990	4/7/2016 11:58:07 AM	\$.15	\$.15	Issue
142437	D5271-1	-2	140320	4/7/2016 11:58:07 AM	\$176.57	\$207.65	Issue